

①

15/0121207 ship 28 AVR

Work Order ID 131127

131127

Page 1

March-26-15 1:43:51 PM

Item ID: D350-607-241 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: AS350/355 Basket Mounting System
Start Date: 3/20/15 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 3/26/15 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: MLS Date: 15-03-31 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-1	A								
100	Document Control	0.00	DAS 27 9-89						
100									
DC									
Doc.Control -USB or Paperwork									
	Memo	0.00							
	Photocopy bluefile & type labels per PPP D350-607-241 CHG001 Paperwork not req'd if packaged with basket								
110	Pick Kit	0.00							
110									
Packaging									
Packaging	Memo	0.00							
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC									
Quality Control	Memo	0.00							

MLS 15-04-27
(2x) DAS 46 9-89 APR 28 2015 2

2 DAS 27 9-89 APR 27 2015
DAS 28 9-89

(2x) DAS 46 9-89 APR 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Picklist Print

March-26-15 1:43:49 PM

Work Order ID: 131127

131127

Parent Item: D350-607-241

D350-607-241

Parent Item Name: AS350/355 Basket Mounting System

Start Date: 3/20/15

Required Date: 3/26/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
as per ECN10-545 DD 10.04.16 verified by:EC
AS PER IIN REV.A DD VERF:JLM

IPP Rev:B

IPP REV:C 13.08.07

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2230-1		Manufactured	No			110	Each	255.0000	4	8			
---------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

2 *D2230-1*
Mounting Lug

DAS
46
9-89

★★

Location	Loc Qty	Loc Code
FG	4	
84136	4	
ST521	96	
110834	2	
115306	80	
116380	3	
116381	11	
ST546A	155	
112595	1	
113437	112	
116381	25	
116382	17	

DAS
27
APR 27 2015

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

March-26-15 1:43:50 PM

Work Order ID: 131127

131127

Parent Item: D350-607-241

D350-607-241

Parent Item Name: AS350/355 Basket Mounting System

Start Date: 3/20/15

Required Date: 3/26/15

Start Qty: 2.00

Required Qty: 2.00

D2230-3

Manufactured No

110

Each

166.0000

4

8

2 *D2230-3*
Mounting Lug

DAS
46
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

158

114921

3

116378

1

116379

2

123324

3

128799

69

129678

80

B128799

8

DAS
28
9-89

D2732

Manufactured No

110

f

613.4000

2

4

2 *D2732*
Rubber Extrusion

DAS
46
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST412

421

117118

421

ST639

192.4

117118

192.4

4

DAS
28
9-89

AN4-15A

Purchased No

110

Each

250.0000

8

16

2 *AN4-15A*
Bolt

DAS
46
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

38

120449

38

ST325A

212

m130358

8

m131320

204

16

APR 27 2015
DAS
28
9-89

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Work Order ID: 131127

Parent Item: D350-607-241

Parent Item Name: AS350/355 Basket Mounting System

131127

D350-607-241

Start Date: 3/20/15

Required Date: 3/26/15

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

110

Each

2,431.000

16

32

DAS

27

9-89

NAS1149D0463.J

WASHER

DAS

46

9-89

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

136

M129390

136

ST269

1898

M130799

507

M131624

1391

m132035

32

DAS

28

9-89

MS21042L4

Purchased

No

110

Each

2,797.000

8

16

DAS

27

9-89

MS21042L 4

Locknut

DAS

46

9-89

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

634

m127813

634

ST260a

1056

m130799

56

m131803

1000

ST305

1065

426

426

m128300

8

m128798

10

m130922

97

m131340

512

m131618

12

APR 27 2015

DAS

28

9-89

March-26-15 1:43:50 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



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6.2 D350-607-045/-045A/-047/-047A HELI-UTILITY-BASKET™

Qty -045	Qty -045A	Qty -047	Qty -047A	Qty -241	Part Number	Description
X					D350-607-045	HELI-UTILITY-BASKET
	X				D350-607-045A	HELI-UTILITY-BASKET
		X			D350-607-047	HELI-UTILITY-BASKET
			X		D350-607-047A	HELI-UTILITY-BASKET
1	1	1	1	X	D350-607-241	BASKET CLAMP KIT INSTALLATION
2	2	5	5		D2022-101	SPACER
				4	D2230-1	LUG
				4	D2230-3	CLAMP
1	1	1	1		D2258-200	LABEL
1	1	1	1		D2324	STRUT
1		1			D2332-041	PROP ASSEMBLY
1	1	1	1		D2530	HANDLE WELDMENT
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D2732-030	RUBBER CUSHION
2	2	2	2		D2931	BUMPER
1	1	1	1		D3265-041	BASKET BASE ASSEMBLY
1	1				D3266-041	BASKET LID ASSEMBLY
		1	1		D3267-041	BASKET LID (OUTSIDE)
		1	1		D3267-043	BASKET LID (INSIDE)
			1		D350-607-143	AUTOMATIC LID OPENER INSTL
	1				D350-607-145	AUTOMATIC LID OPENER INSTL
2	2	2	2		AN3-16A	BOLT
2	2				AN4-7A	BOLT
5	5	5	5		AN4-12A	BOLT
		2	2		AN4-13A	BOLT
				8	AN4-15A	BOLT
1		7	5		AN4-22A	BOLT
1					AN4-24A	BOLT
4	4	4	4		AN5-17A	BOLT
2	2	2	2		MS20600AD4W3	RIVET (OR CR9163-4-3)
12	12	24	24	16	NAS1149D0463J	WASHER (OR AN960JD416)
2		2			NAS1149D0416J	WASHER (OR AN960JD416L)
4	4	4	4		NAS1149D0563J	WASHER (OR AN960JD516)
2	2	2	2		NAS1149DN832J	WASHER (AN960JD8)
		2	2		NAS1515H4	WASHER
4		4			AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
9	7	14	12	8	MS21042L4	NUT (OR MS21042-4)
4	4	4	4		MS21042L5	NUT (OR MS21042-5)